

Date: Tuesday, 5/2/2006 9:06:49 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR ASSEMBLY
Job Number	: 26895		
Estimate Number	: 10480		
P.O. Number	: <i>N/A</i>	Part Number	: D2410
This Issue	: 5/2/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2410
First Issue	: 5/1/2006	Project Number	: N/A
Previous Run	: 25014	Drawing Revision	: A1
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	:	Due Date	: 6/30/2006
Checked & Approved By	:	Qty:	4 Um: Each
Comment	: Est:C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2375308	Insulation 48'of 3"ID*1/
-----	----------	--------------------------



Comment: Qty.: 0.8333 f(s)/Unit Total : 3.3332 f(s)

Insulation 48'of 3"ID\*1/

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

10.6" D2375-3-08

Insulation

*B1810**FF 06/10/23*

4

2.0	D2403	Outer Skin
-----	-------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Outer Skin

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D2403

Outer Skin

*B26904 x3 / B 21844 FF 06/10/23*

4

3.0	D2404	Perforate Sheet,0.125 Ho
-----	-------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Perforate Sheet,0.125 Ho

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D2404

Perforated Sheet

*B25063 x3 / B 21844 x1**FF 06/10/23*

4

4.0	D2411	Valve support, 5052-H34
-----	-------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Valve support, 5052-H34

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D2411

Valve Mtg Angle

*B21844**FF 06/10/23*

4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 5/2/2006 9:06:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 26895

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2412

Insulation filter



Comment: Qty.: 0.7673 sf(s)/Unit Total : 3.0692 sf(s)

Insulation filter

Pick:

Qty	Part Number	Description	Batch
110.5si	D2412	Insulation Filter	B17099

FF 06/10/23

4

6.0

D2413

Intake Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Intake Weldment

Pick:

Qty	Part Number	Description	Batch
1	D2413	Intake Assembly	B25049 x3 / B26905 x1

FF 06/10/23

4

7.0

D2414

Outlet Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Outlet Weldment

Pick:

Qty	Part Number	Description	Batch
1	D2414	Outlet Assembly	B21844

FF 06/10/23

4

8.0

D2416

Mounting angle, 1x.625x.



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty	Part Number	Description	Batch
1	D2416	Mounting Angle	B21844

FF 06/10/23

4

9.0

D2417

Mounting angle, 1x.625x.



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty	Part Number	Description	Batch
1	D2417	Mounting Angle	B21844

FF 06/10/23

4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 5/2/2006 9:06:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 26895

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
8	MS20470AD4-5	Rivet	1849124

Batch

1849124

FF 06/10/23

11.0

MS20600AD4W2

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

Pick:

Qty	Part Number	Description	Batch
8	MS20600AD4W2	Rivet	184747

Batch

184747 4 EXTRA

FF 06/10/23

12.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cherry Rivets

Pick:

Qty	Part Number	Description	Batch
2	MS20600AD4W3	Rivet	14393212

Batch

14393212

FF 06/10/23

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Rivets

Pick:

Qty	Part Number	Description	Batch
12	MS20600AD4W4	Rivet	17101649

Batch

17101649

FF 06/10/23

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2410

FF 06/10/23

FF 06-11-09

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/23	14.0	2 ANG60 10L washers are put in between D2411 valve mtg angle and D2026-101 screw to tighten D2001-08 valve to angle. washers (m 101340)					
		Permanent Change					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/23	14.0	11x MS 20600 AD4 W2 ON inner layer (Perforated)		<del>Scraped</del>	06/10/23 FF			
		2x MS 20600 AD4 W3 ON inner layer (overlapping of Perforated and 2413 intake assembly)		authorized use		06-10-23	QSRD	06-10-23
		2 extra ms 20600 AD4 W3 9 extra ms 20600 AD4 W4		Scraped	06/10/23 FF			
		4x MS 20600 AD4 W2 middle of outer layer		O.K.				

NOTE: Date & initial all entries

not pictures & notes on file, for assembly

Date: Tuesday, 5/2/2006 9:06:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 26895

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*AB M06/11/08 (2)*

16.0

POWDER COATING

POWDER COATING



*M 102341*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

\*\*\*\*Place masking tape on red anodize tube of flare section and access to interior of both ends.\*\*\*\*

*a.m/m L06/12/19 (4x)*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*LB 07/01/03 (4)*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST178 & ST179*

*LB 07/01/03 (4)*

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL



Inspection Level 21

Job Completion



*CS 07/01/04*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Please create Assembly drawings.					 06-10-31	
		Bring holes in .125 on DT8800A, towards the inside. <del>from</del> Better for drilling on Assembly.					 06-10-31	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/08	5	A2403 was damage by rivet gun when installing <sup>the</sup> rivets (1 SCRAP)	<i>[Signature]</i>	take A2403 apart and replace it (B26904) - replace A2375-3-08 (B1810) was damage when taken rivet and A2403 apart	<i>[Signature]</i> 06/11/08	<i>[Signature]</i> 06/11/08	<i>[Signature]</i> 06/11/08	
			<i>[Signature]</i>	- replace MS20600 AW3 (12) M44393 - replace MS20600 AW2 (4) M4747 - replace MS20470 A A4-5 (4) M10491			<i>[Signature]</i>	

NOTE: Date & initial all entries





PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2410	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 ASPIRATOR ASSEMBLY SCALE	
A	95.04.06	NEW ISSUE	
AI	<del>AK</del> 03.04.29	ADDED FLARE	

RELEASED  
9669/0 BW

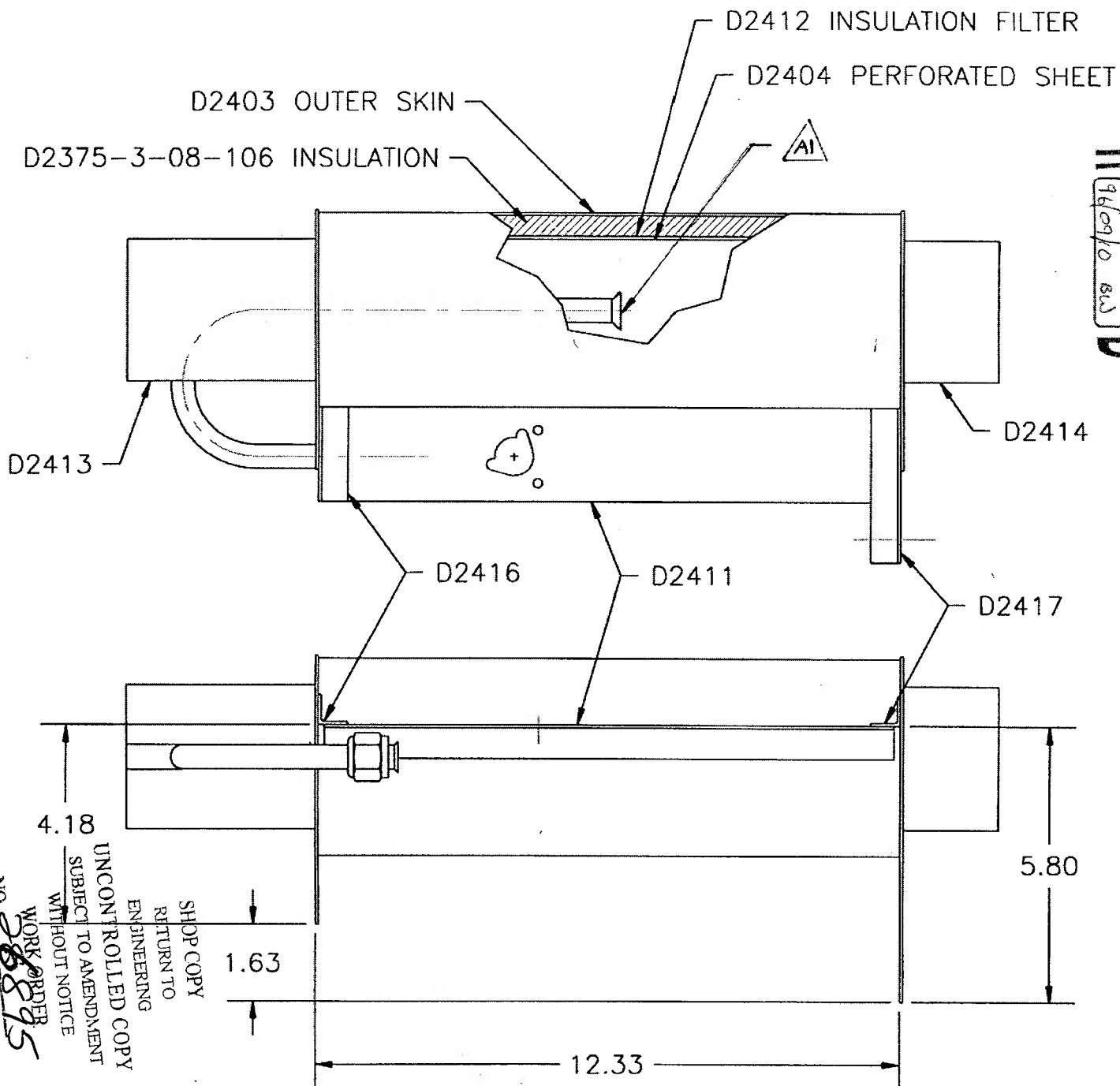
QTY	Part No.	Description
X	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS20600AD4W2	RIVET (CR 9163-4-2)
2	MS20600AD4W3	RIVET (CR 9163-4-3)
12	MS20600AD4W4	RIVET (CR 9163-4-4)
8	MS20470AD4-5	Rivets

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26895

**DART**

PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.W.	APPROVED B.W.	D2410	REV. A
DATE Apr. 6, 1995		TITLE 206 ASPIRATOR ASSEMBLY	SHEET 2 OF 2
			SCALE

**RELEASED**  
1960910 8W



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26895